Work Order ID 100165

April-18-13 1:22:57 PM

D3913-041 Accept

N900040100

Setup Start

Revision ID: Item Name:

Item ID:

Long Basket Base Assemby, 350

Start Date:

4/18/13

Start Oty: 1.00

Cust Item ID:

Required Date: 5/02/13

Req'd Qty: 1.00

Customer:

00165*

Reference:

Approvals:

Process Plan: ML5 Date: 13-04-18 Tooling:

Start

Run

QC: _____ Date: ____ SPC (Y/N):

____ Date: ____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3913	В								
D4020	A								
00	Weld per dwg A/R S.S. rod Batch:	124816 0.00							
100 Large Fab	Large Fab	0.00				/x	CC,	13-4-29	•

Large Fab

1- assemble ribs, weld as per dwg D3913 using DT9610A

inspect before welding mesh

2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends

3- weld hinge (3) and Mounting brackets as per dwg D3913

take lid to locate hinge and bracket

4- Weld D4672-1 blanking plates as per dwg

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Quality Control

QC

Memo

0.00

13-05-01

									DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-C	ONFO	RMANCE / UI	PDATE	QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is Work Order Update	The	Skid-tube Machining ermoforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initia	I A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng Des	cription	Date	Verification	QC Inspector
Doc/Data		T									
Equip/Tooling											
Operator] ;										
Material											
Setup											
Other				,							
Process	']							

Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Bend Grain Ovalized Bending Temperature/Cure BOM/Route Over/Under tolerance Centre Not Concentric to O/S Hardware Part Incorrect Weld Inspection Incomplete Cracks Broken/Damaged Wrong Stock Pulled Part Lost/Missing Instructions Incomplete/Unclear Crushed/Crimped Burrs Part Moved Cuffs Maintenance Contamination Positioned Wrong Heat Treat Countersink Mislabeled Other Power Loss/Surge Misread Inspection Strip in Tube Cut Too Short Drill Holes Offset Ripples in Bend Out of Calibration Drawing Torque Waves in Extrusion Out of Sequence Turning Sequence Finish Folio Wave/Twist in Tube **Outside Dimensions**

Supplier Training

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 400165 A A A COSTA

April-18-13 1:22:57 PM

100165

D3913-041 Item ID: Accept *N900040100* Setup Start **Revision ID:** Item Name: Long Basket Base Assemby, 350 **Start Date:** Start Oty: 1.00 4/18/13 Cust Item ID: Required Date: 5/02/13 Req'd Qty: 1.00 **Customer:** Reference: Run Start Approvals: Date: Tooling: Date: Stop SPC (Y/N): Date: Date: Sequence ID/ Operation Tool ID Set Up/ Tool # Plan Reject Reject Accept Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 120 QC5- Inspect part completeness to step on W/O 0.00 *120* 13-05-01 OC 0.00 Memo Quality Control 125 Pressure Wash per QSI005 4.3 0.00 *195* HandFinish 0.00 Memo Hand Finishing

			1			•					DQA:	Date:	
NCR: Y	Yes	/ No				WORK ORDER NON-	COI	NFORI	MANCE / UP	DATE	QA Closed:	Date:	
<u></u>	-					DISPOSITION		·		AGAINST DE			
Work Orde	er:					DISPOSITION				AGAINST DE	PARTIVICINI	PROCESS	
ı	_					Rework	7		Skid-tube	Crosstube		Water Jet	Engineering
Part N	۷o.	1	•			Scrap			Machining	. Small Fab	Pro	d. Eng. Coor.	Quality
	_	i				Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	۷o					Work Order Update].		Large Fab	Composite		Supplier	
												,	
Root						ption of work order update	1	Initial		tion	Sign &		
Cause		Date ₁	Step	Qty		or Non-conformance	Ct	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data		•											
Equip/Tooling		1										· ·	
Operator	Ш												·
Material	Ш	!											
Setup									,				
Other	Ц		ļ ·										
Process	Ш	Í		1									
Supplier	Ш						1.			•			
Training	Ш												
Unapproved									<u></u>	····	ļ	ļ	
		<u>'</u>			· · · · · · · · · · · · · · · · · · ·		AUI	LT CATE	GORY	· · · · · · · · · · · · · · · · · · ·			
Landii		!				General		7			1		.
	[Bending			ĺ	Bend	1	Grain			Ovalized		Pressure/Forced

Over/Under tolerance

Part Incorrect

Part Moved

Part Lost/Missing

Temperature/Cure

Wrong Stock Pulled

Weld

Heat Treat Positioned Wrong Mislabeled Countersink Power Loss/Surge Other Inspection Strip in Tube Cut Too Short Misread Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration Finish Out of Sequence Turning Sequence Outside Dimensions Folio Wave/Twist in Tube

Hardware

Maintenance

Inspection Incomplete

Instructions Incomplete/Unclear

Cracks

Cuffs

Crushed/Crimped.

Centre Not Concentric to O/S

BOM/Route

Contamination

Burrs

Broken/Damaged

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

100165

Quality Control

Item ID: Revision ID: Item Name:	D3913-041 Long Basket	Base Assemby, 350		Accept	*N900	040	100	ገ*	Setup	Start Stop	*N: *N:	S1* S2*	
Start Date: Required Date: Reference:	4/18/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer:	ID:						.7/	
Approvals:		an:				ate:			Run	Start Stop		R1* R2*	
Sequence ID/ Work Center II 130 *130* Powdercoat Powder Coating		coat 1ST COAT. START TIN OVEN TEN FINISH TIN *********** 2ND COAT START TIN OVEN TEN	es and mask only interior of the second seco	Set Up/ Run Hours 0.00 0.00 of hinge (3) prior to powder O cessary***********************************	Tool ID	Tool#	Plan Code	Accept Qty	Qty	<i>'</i>]	Reject Number	Insp. Stamp	- 5/0
*140 *140* QC		QC3- Inspect Part Finish	1 .	0.00					ϕ	/	3-5-	<u>/</u>	Sy.

0.00

Memo

								•	DQA:	Date: _	
NCR: Yes	/ No				WORK ORDER NON-C	ONFORM	MANCE / UP		QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
Part No.					Rework Scrap Use-as-is Work Order Update	1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	ł	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descripti	on of work order update	Initial	Ad	ction	Sign &		
Cause	Date	Step	Qty	or	Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
oc/Data quip/Tooling Operator Material etup					·						
Process supplier Training				,							
Inapproved	<u>l·</u>	L	<u> </u>	<u> </u>	F" 1	AULT CATE	COPY	2-2		<u> </u>	
					F4		171 JK T				

			TAGE: CATEGORY		· · · · · · · · · · · · · · · · · · ·
Landi	ng Gear	General			
	Bending	Bend	Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	. Temperature/Cure
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped_	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
12.	Cuffs .	Contamination	Maintenance	Part Moved	
1, 1	Heat Treat	Countersink	Mislabeled	Positioned Wrong	p
•	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes	Offset		
	Torque Waves in Extrusion	Drawing	Out of Calibration	ATTACA NA	
	Turning Sequence	Finish	Out of Sequence		
	Wave/Twist in Tube	Folio	Outside Dimensions		

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 100165 * *100165*

April-18-13 1:22:57 PM

Item ID: D3913-041 Accept *N900040100* Setup Start **Revision ID:** Long Basket Base Assemby. 350 Item Name: Start Date: 4/18/13 Start Qty: 1.00 **Cust Item ID:** Required Date: 5/02/13 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: Date: Tooling: Approvals: Date: Stop Date:_____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Number Stamp Qty 150 Assemble as per dwg 0.00 *150* HandFinish 0.00 Memo Hand Finishing Pick Kit 160 QC5- Inspect part completeness to step on W/O *160* QC Memo Quality Control 100157. Identify as per dwg & Stock Location 170 1 & de 13-5-1 *170* Packaging Memo Packaging

		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			
		OA Clasadi	Data	

											and the second s
Work Orde	r·				DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
WOIN OIGC					Rework	i	Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo				Scrap	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
raitiv				•	Use-as-is	The	rmoforming	Finishing	-	e/Packaging	Other
NCR N	lo				Work Order Update	1 1 '''	Large Fab	Composite	1,00,000	Supplier	
WENT I					Work Grace Gpaate	' [22.84				
Root		1		Descri	ption of work order update	Initial	Ad	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Er	g Desc	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling				1							
Operator											
Material		İ									
Setup					•						
Other											
Process											
Supplier		,									
Training											
Unapproved .						<u> </u>					
					F	AULT CA	EGORY				
Landir	ng Gear				General				_		_
	Bending				Bend	Grain	1		Ovalized	<u> </u>	Pressure/Forced
	Centre N	lot Conce	ntric to	o/s	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure
Ī	Cracks				Broken/Damaged	Inspe	ction Incomplete		Part Incorre	ct	Weld
	Crushed	/Crimped			Burrs	Instru	ictions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
Ì	Cuffs				Contamination	Mair	tenance		Part Moved		
Ī	Heat Tre	at			Countersink	Misla	beled		Positioned \	Vrong	_
	Inspection	on Strip in	Tube		Cut Too Short	Misre	ad		Power Loss/	Surge	Other
Ţ	Ripples i	n Bend			Drill Holes	Offse	t				
Ì	Torque \	Naves in I	Extrusio	n	Drawing	Out	f Calibration				
I	Turning	Sequence			Finish	Out	of Sequence				
· •	Wave/T	wist in Tul	be		Folio	Outs	de Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

100165 Page 5

Item ID: Revision ID:	D3913-041			Accept	*N900	040	100)*	Setup	Start	į VI,	S1*
Item Name: Start Date: Required Date: Reference:	4/18/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				Stop	*N:	S2*
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:		1	Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
*180 *180* QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00						13/	5/6	:40

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NO	N-COI	NFORM	MANCE / UF	PDATE	QA Closed:	Date:	
						DISPOSITION			- CS-1	AGAINST DI	PARTMENT		•
Vork Ord	er: ˌ										7	Water Jet	*
Part	No.		! !			Rework Scrap Use-as-is	, []	f	Skid-tube Machining noforming	Crosstube Small Fab Finishing	-	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR	No.					Work Order Update			Large Fab	Composite]	Supplier	
Root		!			Desc	ription of work order updat	te	nitial	A	ction	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Des	cription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining													
							FAUL	T CATE	GORY				
Land	ing (Gear			_	General		1		r	7	[. .
		Bending Centre No Cracks Crushed/Cuffs Heat Trea Inspection Ripples in Torque W	Crimped it n Strip in i Bend	ı Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	ion Incomplete ions Incomplete enance eled	e/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N Power Loss/	ct sissing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Turning S			r	Finish		Out of S	Sequence				

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Picklist Print

April-18-13 1:23:01 PM

Work Order ID: 100165

100165

Parent Item:

D3913-041

D3913-041

Parent Item Name: Long Basket Base Assemby. 350

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC

chg qty's DD 10.04.12 verified by:EC

IPP REV:C 12.07.24

AS PER DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty	per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581		Manufactured	No			100	Each	72.0000		2	2			
D2581					·				**			1C 1	3-4	-29

IPP Rev:B

Mounting Bracket

Location	Lo	c Oty	Loc Code 8503 -		
WA		44 D G	18503 -		(Zx)
98503		44			
WA004		28			
70766		2			
81253		1			
82506		2			
83230		3			
85452		2			
87706		2			
98108		16			
	100	Each	4.0000	1	1

D3913-1

Manufactured

CC 13-4-29

Location WA005 87543 94826

Rib

												DQA:	Dat	te:	
NCR:	Yes /	No				WORK ORDER NON-	cor	NFORM	MANCE / UP	DATE		•		,	
											. (QA Closed:	Da	te:	they are profession of the control o
Work Orde	or:					DISPOSITION				EP	ARTMENT/	PROCESS			
WOIK OIG	C1		,			Rework	٦ أ		Skid-tube	Crosstube		Water Jet			Engineering
Part I	No.					Scrap	1	E .	Machining	Small Fab	┪	Prod. Eng. Coor.			Quality
						Use-as-is]	Therm	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR No.						Work Order Update	_		Large Fab	Composite			Supplier		
Root	1				Descri	ption of work order update		Initial	Δς	tion	Т	Sign &			
Cause		Date	Step	Qty		or Non-conformance	1	nief Eng		ription	ŀ	Date	Verificatio	n	QC Inspector
Doc/Data	r	Dute	3(0)	Qty	<u>`</u>	Tropi comornance	+			<u>P</u>	十				
Equip/Tooling	H									•					
Operator)		•	•									
Material .	П			`											
Setup					1										
Other															
Process															
Supplier	Ш												•		
Training	Ш		ļ												
Unapproved			<u> </u>		L								<u> </u>		
							AUI	LT CATE	GORY						
Landi	ing Ge					General		10		_	\neg	Ovalized		Г	Pressure/Forced
	\vdash	ending			0/s	Bend BOM/Route		Grain Hardwa		 		Ovanzed Over/Under	toloranco	┝	Temperature/Cure
Centre Not Concentric to O/S					U/S -	Broken/Damaged		4	on Incomplete	-	-	Part Incorre		┝	Weld
Cracks Crushed/Crimped					-	Burrs	\vdash	-,	ions Incomplete/	/i Inclear	_	Part Incorrec Part Lost/Mi			Wrong Stock Pulled
Cuffs						Contamination	-	Mainte	•	Unclear		Part Moved	331118		J VVI ONG STOCK I UNEU
	⊢—	ins eat Trea	+		-	Countersink		Mislabe		<u> </u>	_	Positioned V	Vrong		
•	\vdash		ւ ո Strip in	Tube		Cut Too Short	+	Misread				Power Loss/Surge		Other	
	L''''	Special	. July III	· ubc		1000 01101			-	L			. 3-		

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID: 100165

Parent Item:

D3913-041

100165

Location

WA004

Location

WA004

D3913-041

Parent Item Name: Long Basket Base Assemby, 350

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

D3913-15

D3913-3

D3913-7

Rib

Manufactured

No

100

Each

13.0000

Loc Code

Wide Handle Plate

Manufactured

Manufactured

97719

Loc Qty 13 100 Each

7.0000

**

D3913-7

WA005

Loc Qty Loc Code 3 Each 7.0000

CC 13-4-29

Location

WA005

88492

April-18-13 1:23:01 PM

Shop Packet Print

			DQA:	Da
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		

								_	QA Closea:	Date:		
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS		
					Rework	1	Skid-tube	Crosstube]	Water Jet	Engineering	
Part N	No.				Scrap	1	Machining	Small Fab	Pro	Quality		
				•	Use-as-is	Ther	moforming	Finishing	Rec/Store/Packaging		Other	
NCR N	No.				Work Order Update	1	Large Fab	Composite	1			
Root				Descri	ption of work order update	Initial	Initial Action		Sign &			
Cause	Da	te Step	Qty		or Non-conformance	Chief En	g Des	cription	Date	Verification	QC Inspector	
Doc/Data			,									
Equip/Tooling							·					
Operator												
Material			1									
Setup			1			}						
Other												
Process											1	
Supplier		İ					·					
Training			Ì									
Unapproved												
					F	AULT CAT	EGORY					
Landi	ng Gear				General				_			
	Bend	ling			Bend	Grain			Ovalized		Pressure/Forced	
	Cent	re Not Conc	entric to	o/s	BOM/Route	Hardv	are		Over/Under	tolerance	Temperature/Cure	
	Cracl	ks			Broken/Damaged	Inspec	tion Incomplete	<u></u>	Part Incorre	ct	Weld	
	Crus	hed/Crimpe	d.	- [Burrs	Instru	ctions Incomplete	e/Unclear	Part Lost/M	issing	Wrong Stock Pulled	
	Cuffs				Contamination	Main	tenance		Part Moved			
	Heat	Treat			Countersink	Mislal	peled		Positioned \	Wrong	_	
	Inspection Strip in Tube				Cut Too Short	Misre	ad		Power Loss,	/Surge	Other	
Ripples in Bend					Drill Holes	Offset			_			
Torque Waves in Extrusion					Drawing	Out o	Calibration					
Turning Sequence					Finish	Out of Sequence						
	├	e/Twist in T			Folio	Outsid	le Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID: 100165

100165

Parent Item:

D3913-041

D3913-041

Parent Item Name: Long Basket Base Assemby, 350

Start Date: 4/18/13 Start Qty: 1.00

Required Date: 5/02/13

Required Qty: 1.00

D3913-9

Manufactured

94814

70138

100 Each 12.0000

**

CC 13-4-29

D3913-9 Hinge Rib

	Location
	WA
	WA005
	(
No	`

No

No

Loc Qty Loc Code 11 100 Each 8.0000

2

2

Each

**

**

D3916-041

Manufactured

Manufactured

D3916-041

Rib Assembly

Location WA004 WA005

94818 81444

100

Loc Code Loc Qty

14.0000

CC 13-4-29

CC 13-4-29

D3916-5

Light Rib

D3916-5

Location WA004

94163 94698 WA005

77142 82933

Loc Qty

			DQA:	Date:
ICR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		

											QA Closed:	Dat	e:	
Work Orde	er.					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part f	- . No.		·	Rework Scrap Use-as-is Work Order Update				Machining Small Fab Prod. Eng. Coor. Qu					Engineering Quality Other	
Root	Ī		<u> </u>	T	Descri	iption of work order update	Initia	Initial Action		ction	Sign &			
Cause		Date	Step	Qty	1	or Non-conformance	Chief E		Des	cription	Date	Verification	n QC Inspector	
Doc/Data	П	İ	<u> </u>											
Equip/Tooling	П													
Operator	П	i			:									
Material														
Setup		!												
Other														
Process		1						}						
Supplier														
Training	Ш	1	1	1								1		
Unapproved		<u> </u>						L						
		!					AULT CA	TEGO	RY					
Landi	$\overline{}$					Genera!					1			
	-	Bending				Bend	Grai				Ovalized		Pressure/Forced	
		Centre No	ot Conce	ntric to	o/s	BOM/Route		dware		ļ	Over/Under		Temperature/Cure	
	⊢	Cracks !			<u> </u>	Broken/Damaged	—		Incomplete		Part Incorre		Weld	
		Crushed/	Crimped	. '		Burrs .	\vdash		s Incomplete	e/Unclear	Part Lost/M	_	Wrong Stock Pulled	
	Cuffs				<u> </u>	Contamination		ntena		<u> </u>	Part Moved		•	
	Heat Treat				<u> </u>	Countersink	-	abeled			Positioned \	-		
				Cut Too Short	Misr			L	Power Loss,	'Surge	Other			
				Drill Holes	Offs									
						Drawing	├ ──		bration					
	Turning Sequence Finish						Out of Sequence							
Wave/Twist in Tube						Folio	Outs	Outside Dimensions						

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID: 100165

100165

Parent Item:

D3913-041

D3913-041

Parent Item Name: Long Basket Base Assemby. 350

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 1.00

**

Required Qty: 1.00

D4016-1

Manufactured No

100

Each 52.0000

CC 13-4-29

D4016-1

Hinge Half, Base

Location	<u>Lo</u>	c Qty	Loc Code			
ST044		17				
(99098)		17			(3x)	_
WA U		24				_
97664		24				
WA005		11				_
94481		11				
	100	Each	6.0000	1	1	

D4017-7

Manufactured

6.0000

**

CC 13-4-29

D4017-7

Location Loc Qty WA004 95102 WA005 69730 82969 85435 88392 100 9.0000 Each

D4017-9

Manufactured No

**

Rib

<u>ocation</u>	Loc Oty Loc Code	
WA004	· B97757>	(2x)
95203	6 6 7 . 7 = .	
WA005	3	
70341	2	
81445	1	_

			DQA:	Date:
NCR: Yes	/ No	WORK ORDER NON-CONFORMANCE / UPDATE		

		,									QA Closed:	Da <u>t</u> e	
Work Orde	or:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orac	-1.		1			Rework	ا ٦		Skid-tube Crosstube			Water Jet	Engineering
Part N	۷o.					Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
			r			Use-as-is	1		noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	NO.					Work Order Update			Large Fab	Composite]	Supplier	
Root					Descri	tion of work order update	T	nitial	Ac	ction	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data				,		;	.						
Equip/Tooling													
Operator		F	1		}	•	İ						
Material													
Setup													
Other						•							
Process											1		
Supplier		1 ;					1.						
Training					4								
Unapproved		<u> </u>		l									
	,	· · · · · · · · · · · · · · · · · · ·					AUL	T CATE	GORY				
Landi	ng (Gear				General		1		_	-1	r-	
		Bending			L.	Bend		Grain		<u> </u>	Ovalized	· _	Pressure/Forced
	L	Centre No	ot Conce	ntric to	O/S	BOM/Route	L	Hardwa		<u> </u>	Over/Under	⊢	Temperature/Cure
		Cracks				Broken/Damaged	_	4 '	ion Incomplete	_	Part Incorre	├	Weld
	_	Crushed/Crimped				Burrs	<u> </u>	4	tions Incomplete	/Unclear	Part Lost/M		Wrong Stock Pulled
		Cuffs				Contamination	_	Mainte	enance	_	Part Moved		
]	Heat Treat					Countersink		Mislabe	eled		Positioned \	_	¬
}	Inspection Strip in Tube					Cut Too Short		Misread	d	1	Power Loss,	/Surge	Other
	Ripples in Bend					Drill Holes		Offset					·
		Torque W	/aves in E	Extrusio	n _	Drawing		Out of	Calibration				
		Turning S	equence			Finish		Out of Sequence					

Outside Dimensions

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID: \(\pi\)00165

D3913-041

100165 *D3913-041*

Parent Item:

Parent Item Name: Long Basket Base Assemby, 350

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 1.00

**

**

**

Required Qty: 1.00

D4020-11

End Mesh, Basket

Manufactured No

Manufactured

No

No

100

Each

11.0000

CC 13-4-29

CC 13-4-29

13-4-29

Location Loc Qty Loc Code WA007 81442 84972 94553 97684 100 Each 29.0000

D4021-1

D4021-1

Handle Plate

Location Loc Qty Loc Code WA004 89204 94596 3 95039 14 97940 98356 100 4.0000 Each

D4034-041

Manufactured

Aft Upper Rib Assembly

Location WA005

84048 93187 Loc Qty

April-18-13 1:23:01 PM

	1		DQA:	Date:	
NCR.	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			•

	_									QA Closed:	Date			
Work Orde	er:	:				DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part N	Part No. NCR No.					Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	Prod. Eng. Coor Rec/Store/Packagin		Engineering Quality Other		
Root					Descri	ption of work order update	Initial	Α	ction	Sign &				
Cause		ate	Step	Qty		or Non-conformance	Chief En	Des	scription	Date	Verification	QC Inspector		
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved			···											
		1				F	AULT CAT	EGORY	· ·					
Landir	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs					General Bend BOM/Route Broken/Damaged Burrs Contamination	Instru		e/Unclear	Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled		
	Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion					Countersink Cut Too Short Drill Holes Drawing	Mislat Misre Offset Out of	ad .		Positioned \ Power Loss,		Other		
		ning Secure				Finish Folio		Out of Sequence Outside Dimensions						

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID: 100165

100165

Parent Item:

D3913-041

D3913-041

Parent Item Name: Long Basket Base Assemby. 350

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 1.00

**

Required Qty: 1.00

D4034-043

Manufactured

100

Each

5.0000

CC 13-4-29

No

Fwd Upper Rib Assembly

Location WA005

82980 94490 Loc Qty

Loc Code

D4672-1

Manufactured

No

100

100

Each

16.0000

Loc Code

**

CC 13-4-29

· CC 13-4-29

Blanking Plate

Location WA005

88253 94551 Loc Qty 10

sf

596.0191

33

33

**

M304EX0.75-16F

Purchased

No

M304FX0 75-16F

Expanded Metal Flat SS

Location Loc Qty MAT 516.0591180 125113 516.059118 WA 64 124466 64 WA007 15.96 123448 15.96

Loc Code

NCR:	· · · · · · · · · · · · · · · · · · ·														
												QA Closed:	Date):	120 Carlo
Work Ord	er.					DISPOSITION			AGAINST DEPARTMENT/PROCESS						
Part No			Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Fab Use-as-is Thermoforming Finishing			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other					
Root					Descri	ption of work order update		Initial	Α	ction		Sign &			
Cause		Date	Step	Qty		or Non-conformance.	Cr	nief Eng	Des	cription		Date	Verification		QC Inspector
Doc/Data										•					
Equip/Tooling			ļ												
Operator	П														
Material															
Setup					,									1	
Other	П													ļ	
Process	П														
Supplier	П														
Training	П			1											
Unapproved															
						· F	AUI	T CATE	GORY						
Landi	ng G	Gear				General						_			
		Bending				Bend		Grain				Ovalized			Pressure/Forced
	П	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
	П	Cracks				Broken/Damaged		Inspect	on Incomplete			Part Incorre	ct	7	Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

DQA:

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Date:

Wrong Stock Pulled

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish

Picklist Print

April-18-13 1:23:01 PM

Work Order ID: 100165

100165

Parent Item:

D3913-041

D3913-041

Parent Item Name: Long Basket Base Assemby, 350

Start Date: 4/18/13

**

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

AN3-10A

Purchased

No

No

150

Each

166.0000

AN3-10A

Location	Lo	c Oty	Loc Code			
GA		37 ' '	Jen 1 -			
122800		37				
ST351		41				
124221		3				
124858		38				
ST512		88				
122800		88			122800	
	150	Each	0.0000	2	2	
				**	123248	

AN960.ID8

Washer D2931

AN960JD8

Manufactured

NAS1149DN832 Purchased

150

2,216.000 Each

**

Bumper

Location		<u>L</u> c	oe Qty	Loc Code					
GA			218						
	46064		218						
ST021		1998							
	86435		1998						
		150	Each	20.0000					
					*				

D4021-5

Manufactured No

Blanking Plate

Location	Loc Qty	Loc Code
ST084	20	
85065	2	
89059	8	
97893	10	

											DO	QA:_	Dat	te: _	
NCR:	Yes	/ No	1			WORK ORDER NON-C	100	NFORM	ANCE / UPI	DATE			_	-	
			· 	-wi ka .			.,.			A CONTRACTOR OF THE PARTY OF TH	QA Clos	ed:	Da	te:	
Work Orde	or.		ī			DISPOSITION				AGAINST DE	EPARTMENT/PROCESS				
VVOIR OTU	CI		·			Rework	7		Skid-tube	Crosstube	7		Water Jet		Engineering
Part N	No.		i			Scrap	1	E	Machining	Small Fab	1	Proc	l. Eng. Coor.		Quality
				Use-as-is		B	noforming	Finishing	-1		e/Packaging		Other		
NCR I	No.		!			Work Order Update		•	Large Fab	Composite]		Supplier		
			i ·	1 1					A .		Cian C	,		- 1	
Root						ption of work order update	1	Initial		tion	Sign 8	- 1	Verificatio		QC Inspector
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Desci	ription	Date		vernication	11	QC mspector
Doc/Data	Н	1										ļ			
Equip/Tooling	Н	ı					.								
Operator	Н	,													
Material	Н						İ								
Setup	\vdash	ı													
Other	$\vdash\dashv$	1						;							
Process	Н	f													
Supplier Training	Н	!	1												
Unapproved	Н	1										1			
Опаррточеи	1 1		1			F	AUI	LT CATE	GORY		<u> </u>				
Landi	ing G	iear i				General							· · · · · · · · · · · · · · · · · · ·		
		Bending				Bend		Grain			Ovalized	d			Pressure/Forced
	-	Centre No	ot Conce	ntric to (o/s	BOM/Route		Hardwa	re		Over/Ur	nder :	tolerance		Temperature/Cure
	-	Cracks !				Broken/Damaged		Inspecti	on Incomplete	<u> </u>	Part Inc	orrec	t		Weld
	П	Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/I	Unclear	Part Los	t/Mi	ssing		Wrong Stock Pulled
	П	Cuffs [†]				Contamination		Mainte	nance		Part Mo	ved			-
	П	Heat Trea	it			Countersink		Mislabe	led		Position	ied W	/rong		_
	П	Inspection	n Strip in	Tube		Cut Too Short		Misread	i		Power L	.oss/s	Surge		Other
	П	Ripples in	Bend			Drill Holes		Offset		_					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

April-18-13 1:23:01 PM

Work Order ID: 100165

Parent Item:

D3913-041

Parent Item Name: Long Basket Base Assemby. 350

100165 *D3913-041*

Start Date: 4/18/13

**

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

150

Each

1.319.000

Loc Code

MS20600-AD4W3

Cherry Rivets

Location	<u>1</u>	Loc Oty
ST311		1186
	122151	4
	122452	4
	123525	294
	124231	884
WA003		133
	107939	133

MS21042L3

Purchased

No

150 Each 4,739.000

**

MS21042I3

Location	Loc Qty	Loc Code		
FP001	3			
122141	3			
GA	114			
122452	114			
ST314	268			
117885	32			
119017	55			
119075	138			
123265	43			
ST506	4354			
123900	974		1-	
124291	3380		124281	

DQA:	Date:	

WORK ORDER NON-CONFORMANCE / UPDATE

NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Water Jet Engineering Skid-tube Crosstube Rework Part No. Prod. Eng. Coor. Quality Machining Small Fab Scrap Rec/Store/Packaging Other Thermoforming Finishing Use-as-is Large Fab Composite Supplier NCR No. Work Order Update Description of work order update Action Sign & Initial Root Description Verification QC Inspector Date Step Qty or Non-conformance Chief Eng Cause Date Doc/Data Equip/Tooling Operator Material Setup Other **Process** Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Bend Grain Ovalized Bending BOM/Route Temperature/Cure Centre Not Concentric to O/S Hardware Over/Under tolerance Weld Broken/Damaged Part Incorrect Cracks Inspection Incomplete Wrong Stock Pulled Crushed/Crimped. Instructions Incomplete/Unclear Part Lost/Missing Burrs Part Moved Cuffs Contamination Maintenance **Positioned Wrong** Heat Treat Countersink Mislabeled Other Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge **Drill Holes** Offset Ripples in Bend Drawing Out of Calibration **Torque Waves in Extrusion** Turning Sequence Out of Sequence **Finish**

Outside Dimensions

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID: 100165

Parent Item:

D3913-041

Parent Item Name: Long Basket Base Assemby, 350

100165 *D3913-041*

Start Date: 4/18/13

Start Qty: 1.00

12

Required Date: 5/02/13

Required Qty: 1.00

NAS1149F0332P

Purchased

No

150

Each

8,690.000

12

**

NAS1149F0332P

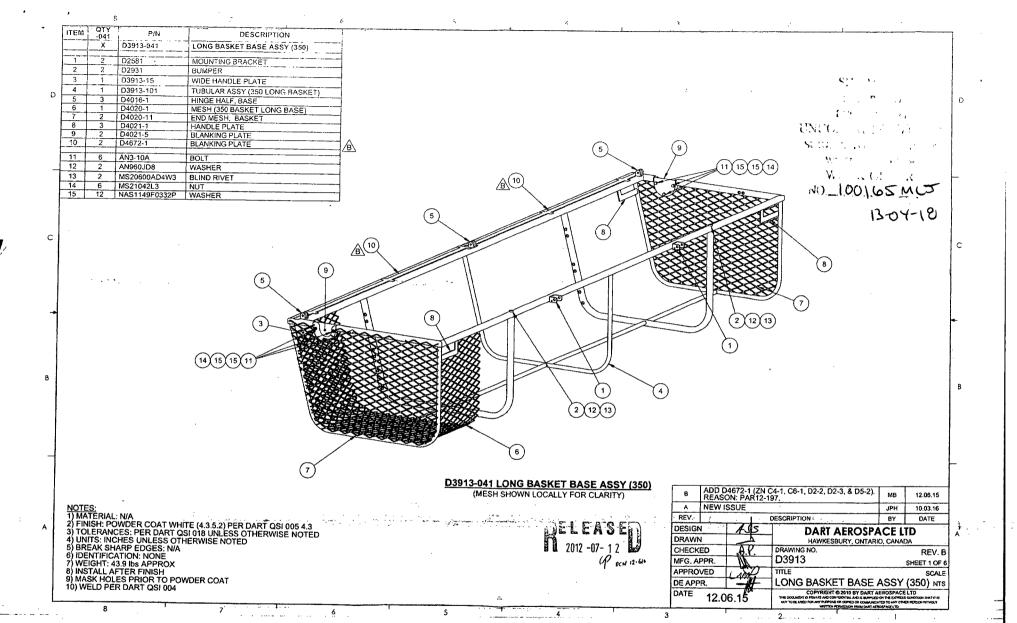
WASHER

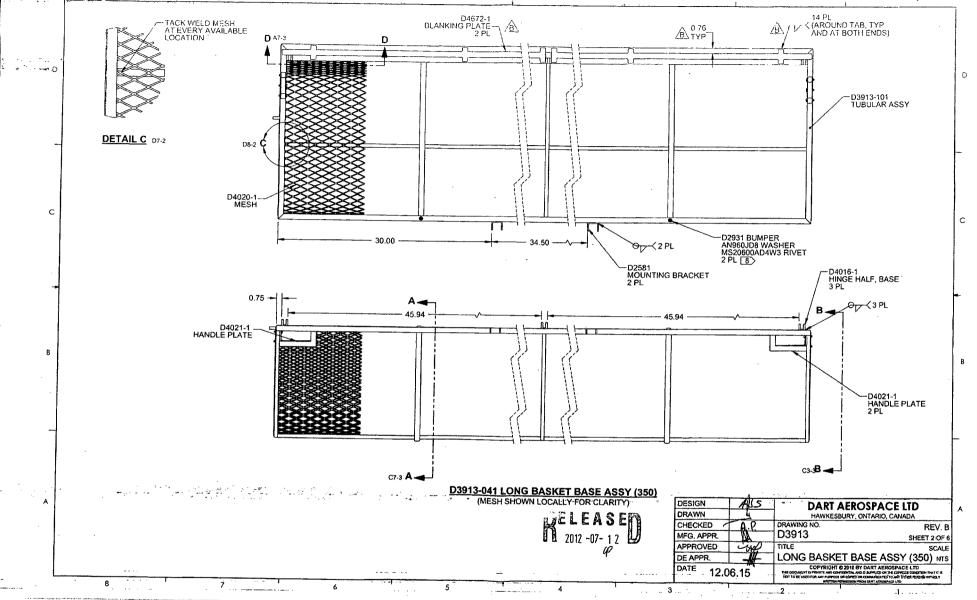
	Location		Loc Oty	Loc Code	
	GA		182		
		122063	182		
:	ST294		158		
		122063	158		
	ST295		3		
		123352	3		
5	st510		8347		
		123900	8347		123500

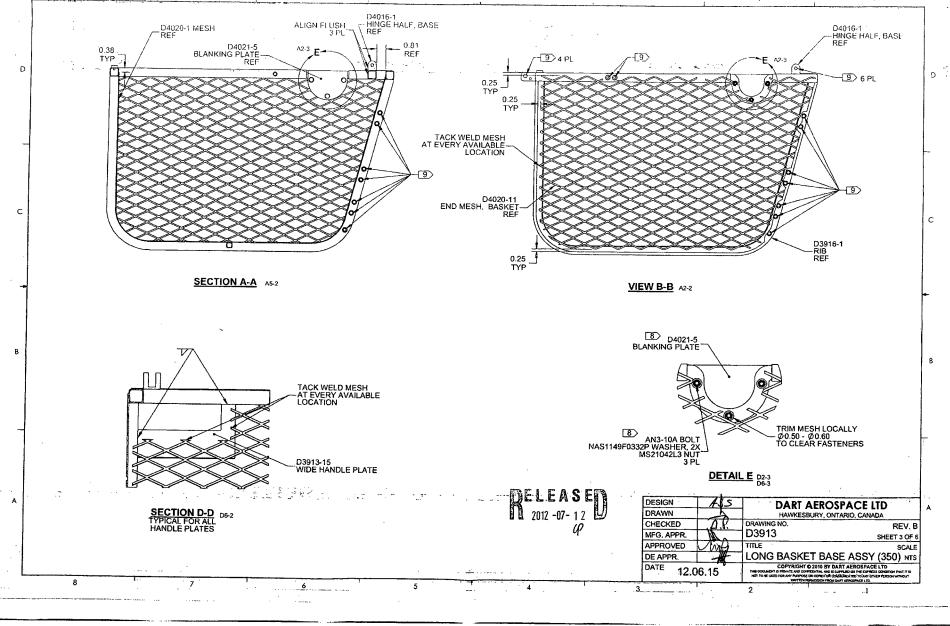
		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

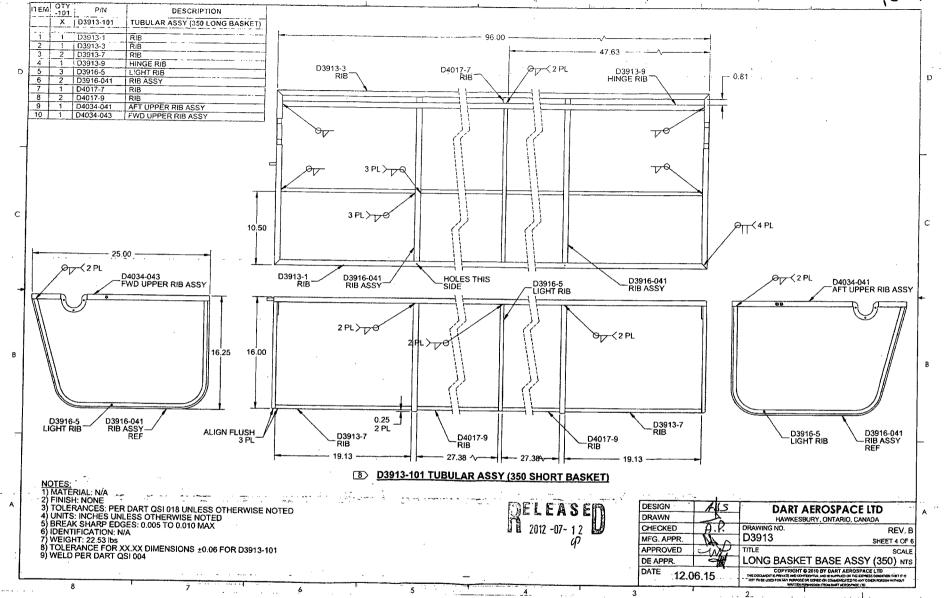
										QA Closed:	Date	
Work Order	:		· · · · · · · · · · · · · · · · · · ·		DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
					Rework	٦		Skid-tube	Crosstube	_	Water Jet	Engineering
Part No	э.				Scrap			Machining	Small Fab	Prod. Eng. Coor.		Quality
		T			Use-as-is	1	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR No	o. ,	:			Work Order Update			Large Fab	Composite		Supplier	
											, ·	
Root					ption of work order update	1	Initial	1	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data	_	r <u>.</u>										
Equip/Tooling	_											
Operator	_											
Material	_										:	
Setup	_ !											
Other	_											
Process	╛,		•									
Supplier												
Training	_]									
Unapproved											<u> </u>	
			<u> </u>			AUI	LT CATE	GORY				
Landing					General		1		_	7	_	- 1
<u> </u>	Bending				Bend	<u> </u>	Grain			Ovalized	-	Pressure/Forced
	Centre N	ot Conce	ntric to C	D/S	BOM/Route	_	Hardwa		<u></u>	Over/Under		Temperature/Cure
	Cracks				Broken/Damaged	<u> </u>	4 '	ion Incomplete		Part Incorre	-	Weld
<u> </u>	Crushed/	'Crimped	-		Burrs	_	4	tions Incomplete	e/Unclear	Part Lost/M		Wrong Stock Pulled
	Cuffs				Contamination		-	enance	_	Part Moved		
	Heat Trea	at			Countersink		Mislab			Positioned \		
	Inspectio	n Strip in	Tube		Cut Too Short		Misrea	d		Power Loss/	/Surge	Other
	Ripples in	n Bend			Drill Holes		Offset		·			
	Torque V	Vaves in I	Extrusion	L	Drawing		Out of	Calibration				
	Turning S	Sequence			Finish	L	Out of	Sequence				
ı	Wave/Twist in Tube		Folio		Outside	e Dimensions						

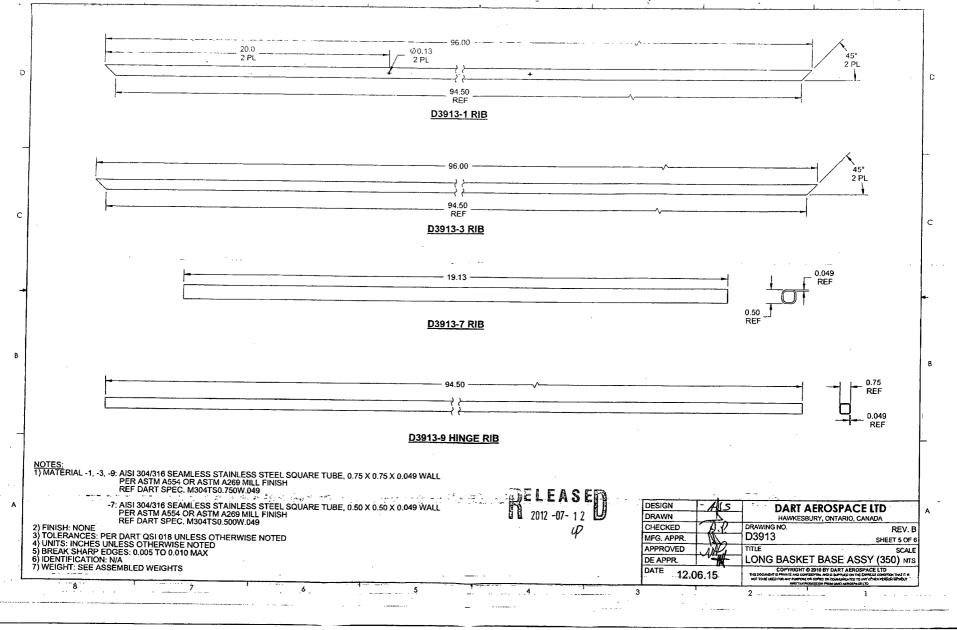
H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



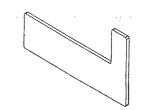


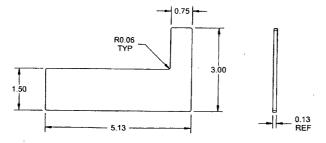






С



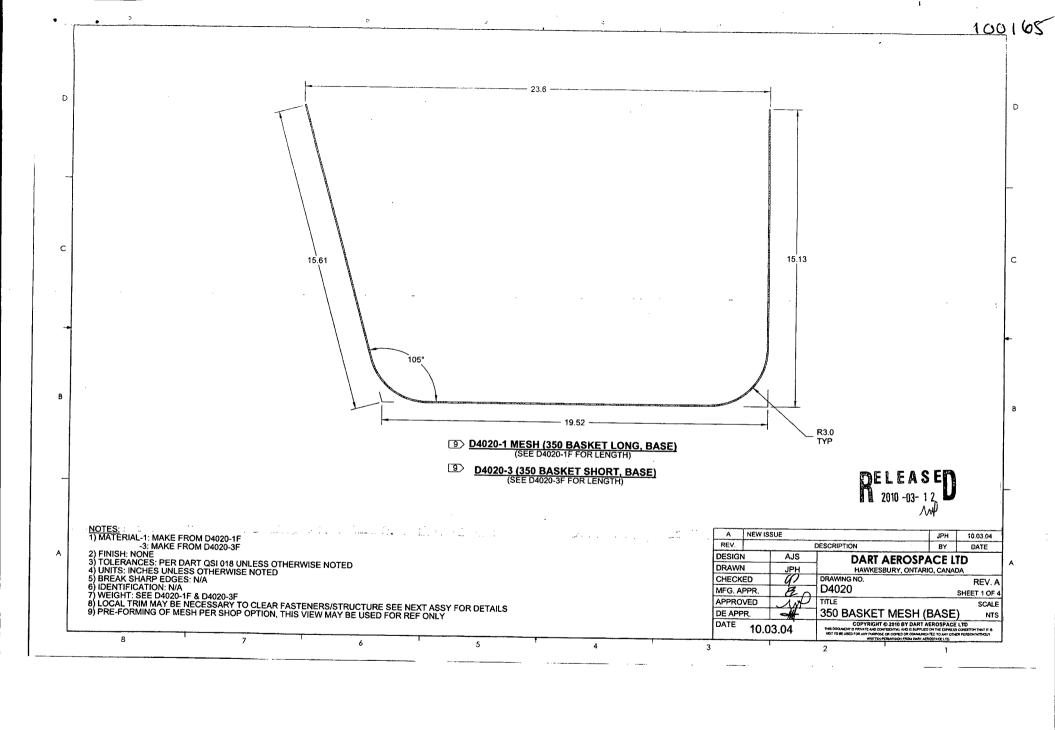


D3913-15 WIDE HANDLE PLATE

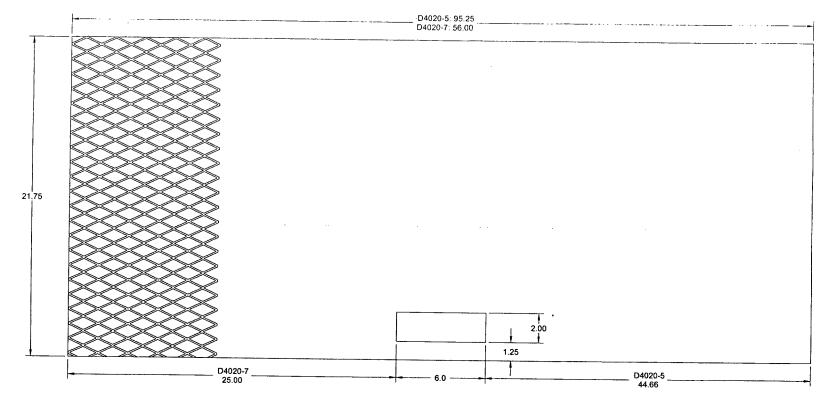
D

NOTES:
1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 - REF DART SPEC M304S11GA
2) FINISH: NONE
3) TOLERANCES: PER DART GSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.31 lbs

	4							
DESIGN	4.5	DART AEROSPACE LTD						
DRAWN	1.7	HAWKESBURY, ONTARIO, CANA						
CHECKED	A.V.	DRAWING NO.	REV. B					
MFG. APPR.	M	D3913	SHEET 6 OF 6					
APPROVED	100	TITLE	SCALE					
DE APPR.	4	LONG BASKET BASE ASSY	(350) NTS					
DATE 12.0	6.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD THE DOCLARM IS PRIVATE AND COMPRIDED IN, AND IS SUPPLIED ON THE EXPRESS CONCERN THAT IT IS NOT TO BE USED FOR ANY PLANFOLD ON CONCE OF CONCERNMENTED TO ANY FOR PRIVATE WHITE PROMISSION RECEIVED HAVE ANY PLANFOLD TO THE PRIVATE OF THE PRIVATE ANY PROPERTY AND THE PRIVATE AND THE PRIVATE OF THE PRIVATE AND THE PRIVATE OF THE PRIVATE AND THE PRIVATE OF THE PRIVATE AND THE PRIVATE OF THE PRIVATE AND THE PRIVATE OF THE PRIVATE AND THE PRIVATE OF						



100165



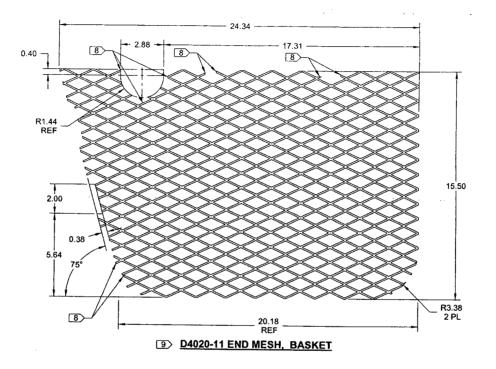
D4020-5 MESH (350 BASKET LONG, LID)
 (LOCAL SECTION MESH SHOWN FOR CLARITY)

9 D4020-7 MESH (350 BASKET SHORT, LID) (LOCAL SECTION MESH SHOWN FOR CLARITY)

· · · · · · · · · · · · · · · · · · ·	
NOTES: 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F	9
1) MATERIAL: AISI 304/316 EXPANDED STAINI ESS STEEL MESH 3/4_16E	
REF DART SPEC, M304EX0.75-16F	
2) FINISH: NONE	
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED	
4) UNITS: INCHES UNLESS OTHERWISE NOTED	
5) BREAK SHARP EDGES: N/A	
6) IDENTIFICATION: N/A	
7) WEIGHT -5: 0.80 lbs APPROX	
-7: 4.49 lbs APPROX	
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DI	TAIL O
9) TOLERANCE ON XX.XX DIMENSIONS + 0.06.	EIAILS
S) TOLLIVETOL ON ANALYMENDIONE TOUR	

D

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	(P)	DRAWING NO. REV. A	
MFG. APPR.	E	D4020 SHEET 2 OF 4	
APPROVED	UND.	TITLE SCALE	
DE APPR.	`- W	350 BASKET MESH (BASE) NTS	
DATE 10.03.04		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND COMPEDMENT, AND IS SUPPLED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPED OR COMPANDATED TO MY OTHER PERSON NETHOUT WRITTEN PROMISSION FROM DART ARRESPACE LTD	



8

NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 1.22 lbs
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06.

DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA AJS DRAWN JPH CHECKED DRAWING NO. REV. A D4020 MFG. APPR. SHEET 3 OF 4 APPROVED TITLE SCALE 350 BASKET MESH (BASE)

COPYRIGHT & 2010 BY DART AEROSPACE LTD

THE COCCURRY OF MANY THE CONTROLL OF THE CONTR DE APPR. NTS DATE 10.03.04

